

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024634**Date Inspected:** 07-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Changxing Island **Location:** Shanghai, China**CWI Name:** Lv Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Vikram Singh was present during the times noted above for observations relative to the work being performed at ZPMC.

WELDING

OBG Bay 14

This QA Inspector randomly observed the following work in progress:

Flux Cored Arc Welding (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as DP3174-001-294 located on Deck Panel Diaphragm to Deck Plate of the OBG Segment 14W. The welder is identified as 048696. AB/F Quality Control (QC) is identified as Mr. Kim Xiao. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3020D-317 located on floor beam stiffener to longitudinal diaphragm of the OBG Segment 14W. The welder is identified as 201215. AB/F Quality Control (QC) is identified as Mr. Kim Xiao. The welding variables recorded by QC appeared to comply with WPS-B-T-2131-ESAB.

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This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as DP3167-001-357 located on Deck Plate of the OBG Segment 14E. The welder is identified as 206623. ZPMC Quality Control (QC) is identified as Mr. Xieming Feng. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3014J-010 located on floor beam flange to deck panel diaphragm of the OBG Segment 13CW. The welder is identified as 066239. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

Shielded Metal Arc Welding (SMAW)

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as DP3165-001-030 located on Deck Plate of the OBG Segment 14E. The welder is identified as 066326. ZPMC Quality Control (QC) is identified as Mr. Xieming Feng. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as SEG3020K-026 located on bottom plate to S.A of the OBG Segment 14W. The welder is identified as 045246. AB/F Quality Control (QC) is identified as Mr. Kim Xiao. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-REPAIR & repair report B-CWR-2692.

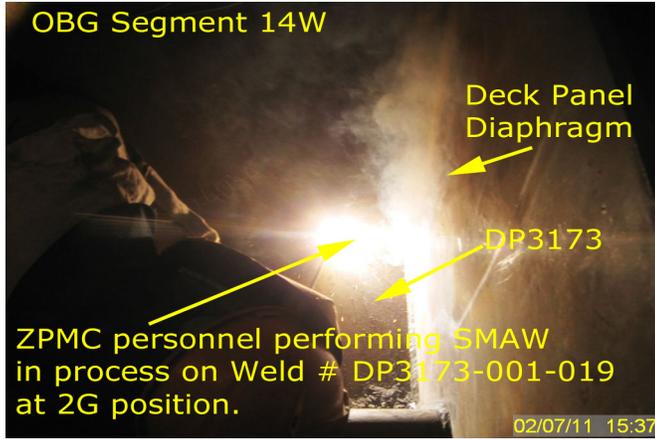
This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as SEG3013AW-024 located on edge plate to floor beam of the OBG Segment 13AW. The welder is identified as 066261. AB/F Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-REPAIR & repair report B-WR-20171.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as DP3173001-019 located on deck plate to diaphragm of the OBG Segment 14W. The welder is identified as 067904. AB/F Quality Control (QC) is identified as Mr. Kim Xiao. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-Tc-U4b-FCM-1. For details see image below:

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Singh, Vikram	Quality Assurance Inspector
Reviewed By:	Patterson, Rodney	QA Reviewer
